

## Claims

1. A method for manufacturing a sight gauge shield, said method comprising:

mating first and second mold portions about first and second spaced-apart cores to define: (i) a first annular void between said first core and said first and second mold portions; and, (ii) a second annular void between said second core and said first and second mold portions, wherein said first and second mold portions respectively comprise first and second stand-up portions, and wherein said first stand-up portion cooperates with said second mold portion to define a first sidewall void and wherein said second stand-up portion cooperates with said first mold portion to define a second sidewall void;

molding opposite first and second annular end portions of a gauge shield member by filling said first and second annular voids with a polymeric material; and,

molding first and second sidewalls of said gauge shield member as a one-piece construction with said first and second annular end portions by filling said first and second sidewall voids with said polymeric material.

2. The method as set forth in claim 1, wherein said first and second cores are cylindrical.

3. The method as set forth in claim 2, further comprising:

contacting said first core with at least one of said first and second mold portions at a first metal-on-metal contact zone to prevent said polymeric material from flowing into said first metal-on-metal contact zone; and,

contacting said second core with at least one of said first and second mold portions at a second metal-on-metal contact zone to prevent said polymeric material from flowing into said first metal-on-metal contact zone.

4. The method as set forth in claim 1, wherein said first and second sidewall voids comprise respective first and second circular arc segment void portions.

5. The method as set forth in claim 4, wherein:

said first sidewall void is defined at least partially between an arcuate outer surface of said first stand-up portion and an arcuate inner surface of said second mold portion; and,

said second sidewall void is defined at least partially between an arcuate outer surface of said second stand-up portion and an arcuate inner surface of said first mold portion.

6. The method as set forth in claim 5, wherein said arcuate outer surfaces of said first and second stand-up portions and said arcuate inner surfaces of said first and second mold portions between which said first and second sidewall voids are each defined as a circular arc segment.

7. The method as set forth in claim 6, wherein said first and second sidewall voids are arranged in opposed facing relation.

8. The method as set forth in claim 7, wherein said first and second sidewall voids are arranged in diametrically opposed facing relation.

9. The method as set forth in claim 8, further comprising:  
separating said first and second mold portions; and,  
extending at least one ejector pin from said first mold portion to eject said polymeric material from said first mold portion.

10. The method as set forth in claim 9, wherein said at least one ejector pin engages said polymeric material on in inner surface thereof that defines a through bore.

11. A sight gauge shield constructed according to the method of claim 8.

12. A sight gauge shield comprising:

a one-piece molded polymeric member that comprises: (i) first and second end portions located at opposite first and second ends; (ii) a central portion located axially between said first and second end portions; (iii) a through-bore that extends between and through said first and second opposite ends, said through bore defined by an inner surface;

first and second sidewall portions that extend axially between and interconnect said first and second opposite end portions, wherein said first and second sidewall portions located in opposed facing relation to each other and are separated by first and second elongated, axially extending slots.

13. The sight gauge shield as set forth in claim 12, further comprising first and second webs that span said first and second elongated, axially extending slots, wherein said first web is located closer to said first end portion and said second web is located closer to said second end portion.

14. The sight gauge shield as set forth in claim 13, further comprising:  
a first pair of webs arranged in opposed facing relation with each other and respectively spanning said first and second slots; and,  
a second pair of webs arranged in opposed facing relation with each other and respectively spanning said first and second slots;  
wherein said first pair of webs is located axially closer to said first end of said member and said second pair of webs is located axially closer to said second end of said member.

15. The sight gauge shield as set forth in claim 12, wherein said inner surface that defines said through-bore is cylindrical.

16. The sight gauge shield as set forth in claim 12, wherein said first and second sidewall portions are diametrically opposed relative to each other.

17. A liquid dispensing urn comprising:  
a liquid dispensing faucet;  
a sight gauge connected to said faucet; and,  
a sight gauge shield in which said sight gauge is received, said sight gauge shield comprising:  
a one-piece molded polymeric shield member that comprises: (i) first and

second end portions located at opposite first and second axial ends; (ii) a central portion located axially between said first and second end portions; (iii) a bore that extends between said first and second opposite ends, said bore defined by an inner surface;

first and second sidewall portions that extend axially between and interconnect said first and second opposite end portions, wherein said first and second sidewall portions located in opposed facing relation to each other and are separated by first and second elongated, axially extending slots.

18. The urn as set forth in claim 17, further comprising first and second webs that span said first and second elongated, axially extending slots of said one-piece shield member, wherein said first web is located closer to said first end portion and said second web is located closer to said second end portion.

19. The urn as set forth in claim 17, further comprising:

a first pair of webs arranged in opposed facing relation with each other and respectively spanning said first and second slots of said one-piece shield member; and,

a second pair of webs arranged in opposed facing relation with each other and respectively spanning said first and second slots of said one-piece shield member;

wherein said first pair of webs is located axially closer to said first end of said shield member and said second pair of webs is located axially closer to said second end of said shield member.

20. The urn as set forth in claim 17, wherein said inner surface that defines said bore is cylindrical.

21. The urn as set forth in claim 20, wherein said first and second sidewall portions are diametrically opposed relative to each other.